

Work Order ID 151987

Friday, October 14, 2016 1:56:36 PM

151987

Page 1

Item ID: D3278-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Spacer

Start Date: 11/22/2016 Start Qty: 40.00

40

Cust Item ID:

Required Date: 11/24/2016 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan: **DAS**
21
9-89 Date: **OCT 17 2016**

Tooling:

Date:

Run Start ***NR1***

QC: Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D3278	Rev C
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100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.13

FLOW CNC Waterjet

1-Cut as per Dwg D3278

Dwg Rev: **C**Prog Rev: **C****(42)****DE 16/10/23**

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.07

Quality Control

(42)**DE 16/10/23**

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.13

Quality Control

(42)**DAS**
38
9-89
OCT 24 2016

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Item ID: D3278-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Spacer
Start Date: 11/22/2016 Start Qty: 40.00 ***40*** Cust Item ID:
Required Date: 11/24/2016 Req'd Qty: 40.00 ***40*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab								
Small Fab	Memo	0.13				42x			16/10/27
Small Fab	1-C'sink as per dwg D3278 2-Debur								
140		0.00							
140	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.13				(42)			9102 7-7-100
Quality Control									
150		0.00							
150	Identify as per dwg & Stock Location: _____								
Packaging	Memo	0.07				42			
Packaging	LOCATION : GA								

DAS 36 9-89

DAS 38 9-89

DAS 6 9-89

OCT 31 2016

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Item ID: D3278-3 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Spacer
Start Date: 11/22/2016 Start Qty: 40.00 ***40*** Cust Item ID:
Required Date: 11/24/2016 Req'd Qty: 40.00 ***40*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00					DAS 21 9-89		OCT 3 1 2016
160									
QC	Memo	0.67							
Quality Control							DAS 21 9-89		OCT 3 1 2016

Picklist Print

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Work Order ID: 151987

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Parent Item: D3278-3

D3278-3

Parent Item Name: Spacer

Start Date: 11/22/2016

Required Date: 11/24/2016

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP . A 04.04.19 New issue KJ/JLM
IPP B 07.09.06 Rev C dwg EC Verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINS0.125		Purchased			No	100	sf	29.6000	0.0344	1.44842			

MDELRINS0 125

Black Delrin Sheet .125

1.5 Dec 16/10/23

Location

Loc Qty

Loc Code

MAT019

29.6

124463

0.7

m134605

28.9

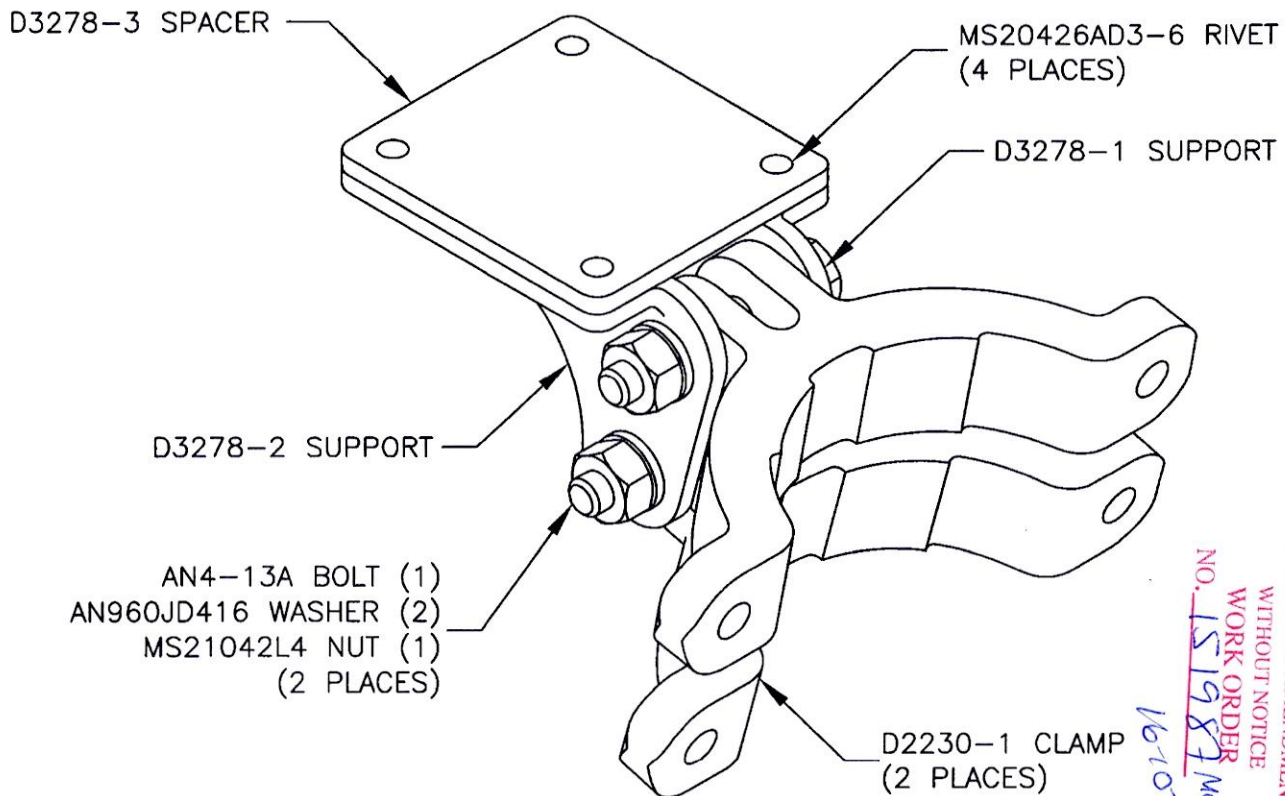
7
8



DESIGN 97	DRAWN BY JC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

RELEASED
07-08-06

D3278-041 SUPPORT ASSEMBLY



Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

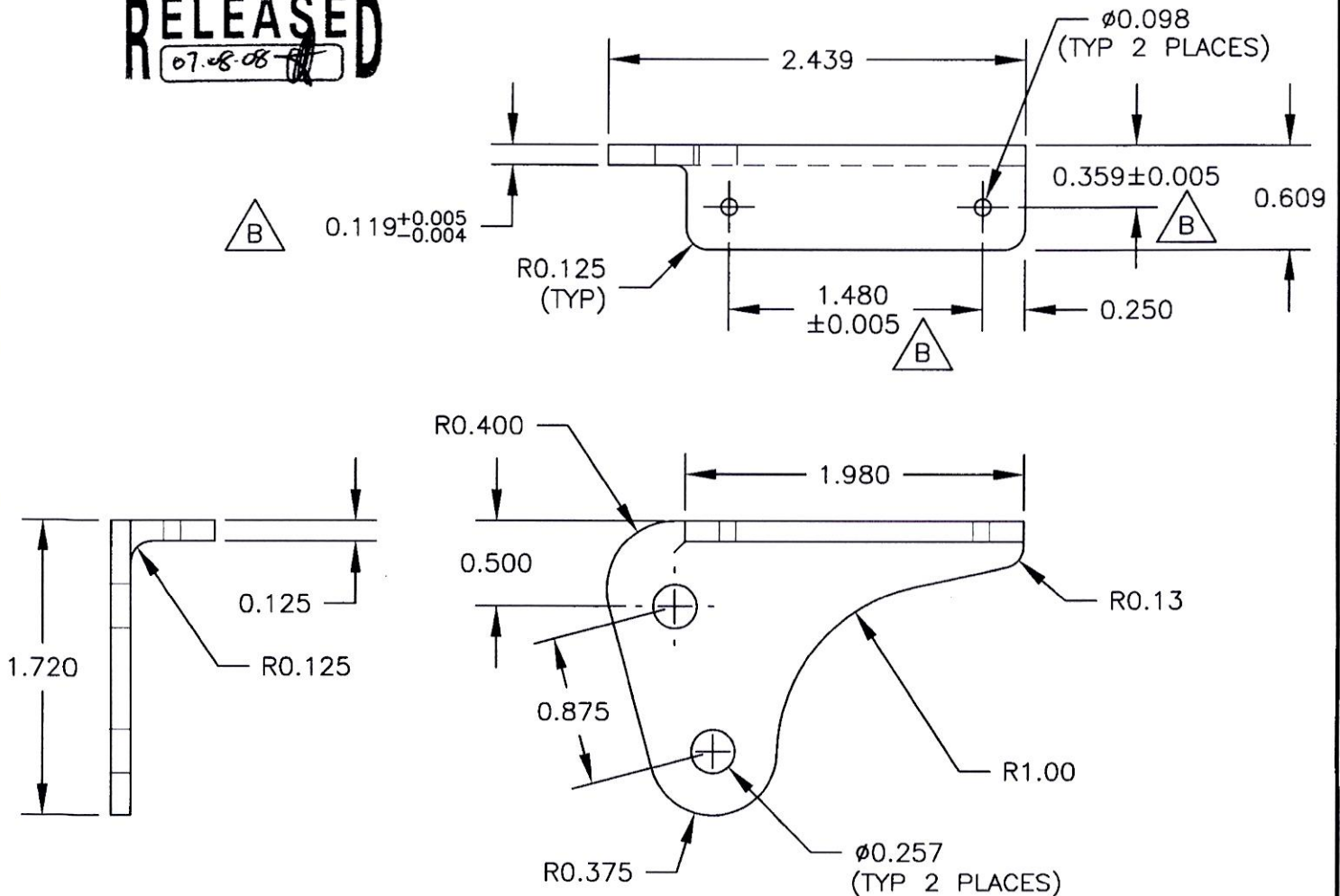
SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 151987M5
16-10-17

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DESIGN <i>JP</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07.08.08**D3278-1 SUPPORT (SHOWN)****D3278-2 SUPPORT (OPPOSITE)**

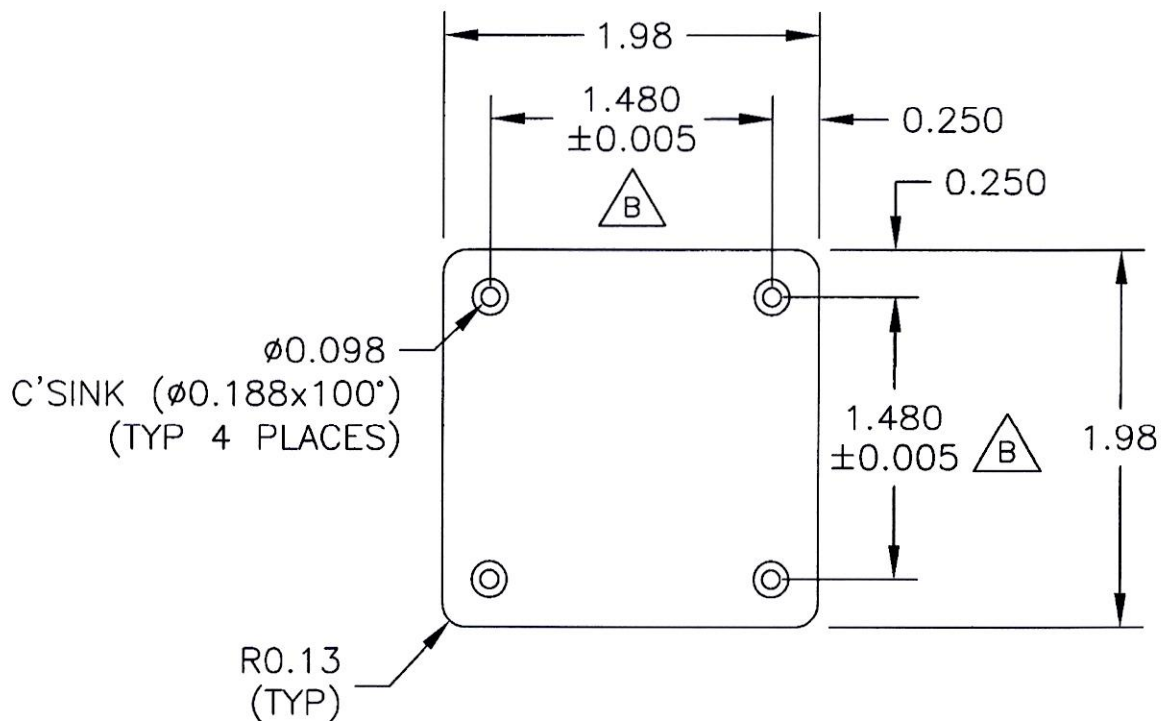
- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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DESIGN <i>GP</i>	DRAWN BY <i>DC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>JB</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24	TITLE SUPPORT ASSEMBLY		SCALE 1:1

RELEASED
07.08.08**D3278-3 SPACER**

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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